

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	ADJUSTABLE ENGINE MOUNT KIT (205)
Job Number	:	31650			
Estimate Number	:	10548			
P.O. Number	:	N/A	Part Number	:	D205708011
This Issue	:	4/12/2007 S.O. No. : N/A	Drawing Number	:	B80701 REV C
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : PURCHASED PARTS	Drawing Revision	:	C
Previous Run	:	29919	Material	:	N/A
Written By	:		Due Date	:	4/12/2007 Qty: 4 Um: Each
Checked & Approved By	:	JLM/AP			
Comment	:	Est C 06/01/31 Added MS206136C12 JLM/AP			

1.0

DC

DOCUMENT CONTROL



Photocopy bluefile and create labels per PPP D205-708-011, CHG001

KJ 07.04.13

2.0

PG

PURCHASING



Issue P/O: 3544 for:

6	✓	D3284-001	(B80702-1)	Sleeve
2	✓	D3284-003	(B80703-1)	Stud
4	✓	D3284-005	(B80704-1)	Stud
6	✓	D3284-007	(B80705-1)	Stud
6	✓	NAS509-12	Nut	
6	✓	NAS509L12	Nut	Stud

C207104113

4

-To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Receive & Inspect For Transit Damage
Ensure Certificate of Conformity is attached

674/18

(4)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Inspect assembly. Visually inspect thread, fit and cad plating

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 31650

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3284001

Sleeve



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-001 Sleeve

B31650

6.0

D3284003

Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Stud

Pick:

Packing Kit (Note: (1) D205-708-011 Kit includes all parts listed below)

Qty Part Number Description Batch

2 D3284-003 Stud

B31650

7.0

D3284005

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

4 D3284-005 Stud

B31650

8.0

D3284007

Stud



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-007 Stud

B31650

9.0

D3284009

Bearing



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bearing

Pick:

Packing Kit (Note: (1) D204-708-013

[Signature]
Form: process

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 31650

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description:

(Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-009 Bearing

~~B37650~~ B29938 YX B31705 20X

10.0 D3284011

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bearing

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

1 D3284-011 Bearing

~~B37650~~ B29939

11.0 MS206136C16

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

8 MS20613-6C16 Rivet

~~M19349~~ ✓

C10's cut

12.0 MS206136C18

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

8 MS20613-6C18 Rivet

~~M19349~~ ✓

remove 4 rivet as per NCR 198

13.0 MS206136C19

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D205-708-011

(Kit includes all parts listed below)

Qty Part Number Description Batch

8 MS20613-6C19 Rivet

~~M19349~~ ✓

add 4 Rivet as per NCR 198

4 x M19313 EJP 07/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 31650

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

NAS50912

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509-12	Nut	B31650

15.0

NAS509L12

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509L12	Nut	B31650

16.0

MS206136C12

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
2	MS206136C12	Rivet	M110089

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



C207104123 (4)



Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-708-011

Location:

PPP Rev:

NEVA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 27/04/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:17 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 31650

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

D205708011

Job Completion



U A. J. - 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

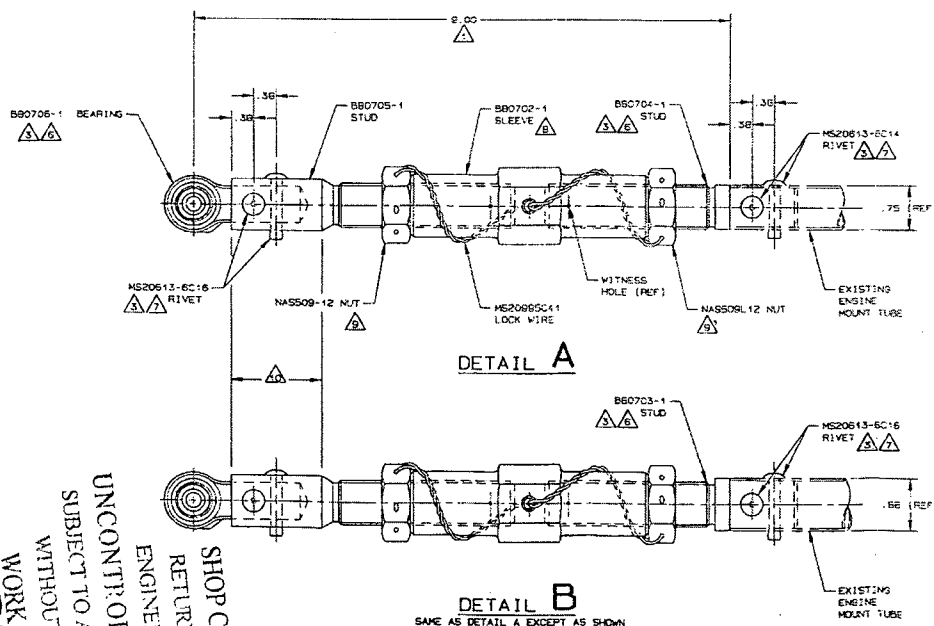
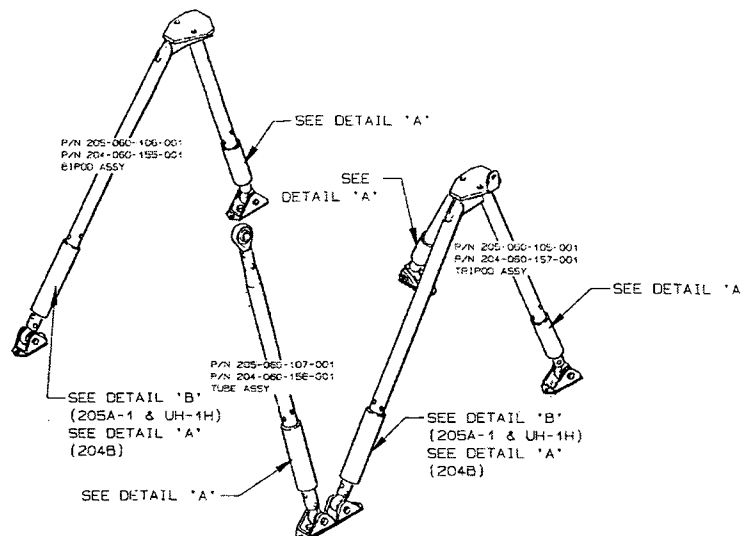
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOTES:

1. CUT EXISTING ENGINE MOUNT TUBE AT DIMENSION SHOWN.
2. DETERMINE OUTSIDE DIAMETER OF TUBE .005/.010 AND CHAMFER INSIDE DIAMETER .015/.025.
3. BOTTOM OUT BEARINGS IN B60705 STUD AND B60703/B60704 STUDS IN TUBE. POSITION RIVET HOLES AS SHOWN AND LINE DRILL PARTS .154 DIA (#10 DRILL).
4. DISASSEMBLE PARTS AND DENERG.
5. ZINC CHROMATE PRIME TUBE ASSY ALL OVER USING TT-P-1757, COLOUR GREEN.
6. RE-ASSEMBLE PARTS WET WITH HYSCOL ADHESIVE E4934.
7. INSTALL RIVETS WET WITH HYSCOL ADHESIVE E4934.
8. FILL SLEEVE WITH CORROSION PREVENTIVE COMPOUND MIL-C-16173 SUFFICIENT TO CAUSE SQUEEZE OUT, THEN ASSEMBLE THREADED PARTS AS SHOWN.
9. FOR AIRCRAFT INSTALLATION, BACK OFF NUTS AND ORIENT BEARINGS TO SUIT ENGINE DECK FITTINGS. ADJUST LENGTHS OF INDIVIDUAL TUBES WITH SLEEVE TO OBTAIN CORRECT ENGINE/TRANSMISSION ALIGNMENT PER BELL MAINTENANCE MANUAL. MAKE SURE STUDS ARE STILL VISIBLE THROUGH WITNESS HOLES. TORQUE NUTS 400 TO 500 IN-LEBS AND LOCKWIRE AS SHOWN. SEAL LOCKWIRE HOLES IN SLEEVE AND AROUND NUT/THREAD INTERFACE WITH SEALANT PER MIL-S-8802.
10. ZINC CHROMATE WHERE INDICATED USING TT-P-1757, COLOUR GREEN.




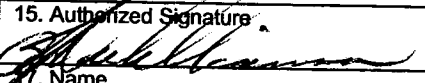
RELEASED FOR
OFFICIAL USE ONLY
OCT 14 1999
AEROCONSULTING SERVICES LTD.

REV.	Date	Description of changes	by	approved
N/C	08 JAN 99	INITIAL RELEASE	TM	TIM MARTIN
A	19 MAY 99	REV. MATL LIST, ADD B60706-1 BRS.	SW	TIM MARTIN
B	01 FEB 00	CON B60701A1 INCORPORATED	TM	TIM MARTIN
C	09 OCT 03	CON B60701A1 INCPD	TM	Meta

QTY	DESCRIPTION	MATERIAL
AR	E4934	ADHESIVE
AR	DEXTER/HYSCOL	
6	B60706-1	BEARING
AR	ACS	
AR	B60705-1	STUD
AR	MIL-S-8802, CLASS B	SEALANT
AR	MIL-C-16173, GRADE 1	CORROSION PREVENTIVE COMPOUND
AR	MS20995C41	LOCK WIRE
12	B	MS20613-BC14
12	16	MS20613-BC16
6	6	NASS09-12
6	6	NASS09-12
6	4	B60705-1
6	2	B60704-1
6	6	B60703-1
1	-3	INSTALLATION
1	-1	INSTALLATION
-3	-1	PART NO.
QUANTITY PER UNLESS OTHERWISE SPECIFIED	APPROVALS	DATE
dimensions are in inches	7 MARTIN	27 JAN 99
Tolerances on:	CHECKED:	
Decimals .XXX ± .010	PROJECT ENGINEER	
Angles .XX ± .03		
.X ± .1		
USED ON	STRESS:	
DWG SIZE: D	AVIONICS:	

NORTH AERO INDUSTRIES 1845 ST. MATTHEWS AVENUE WINNIPEG, MANITOBA R3H 0A8	
INSTALLATION - ENGINE MOUNT, ADJUSTABLE, BELL 204/205	
CODE IDENT NO. 36929	DWG. NO. B80701
REV. C	
SCALE: FULL	SHEET 1 OF 1

NO. 31650
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

1. Approving national aviation authority / country TRANSPORT CANADA		2. AUTHORIZED RELEASE CERTIFICATE TCCA 24-0078				3. Form tracking No. SO16413-1	
4. Approved organization name and address  AMO 88-97		5. NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada				6. Work Order/Contract/Invoice PO 00003544	
6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work	
1	SLEEVE	B80702-1	BELL 205A-1 205B 204B UH-1H	24	BATCH # 07-1253	Manufactured	
2	7/8 STUD	B80703-1	BELL 205A-1 205B UH-1H	8	BATCH # 07-1040	Manufactured	
13. Remarks These Aeronautical Products conform to approved data in accordance with TCCA STC Number SH99-11 and (FAA STC Number SR00953NY and SR01395NY).							
14. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 13.				19. <input type="checkbox"/> CAR 571.10 Maintenance Release <input checked="" type="checkbox"/> Other regulations specified in block 13 Certifies that, except where otherwise specified in block 13 the work identified in block 12 and described in block 13 was performed in accordance with CAR 571.10			
15. Authorized Signature 		16. Certificate / Approval Ref. No. AMO 88-97		20. Authorized Signature N/A		21. Certificate / Approval Ref. No. N/A	
17. Name R. D. Williamson		18. Date (DD MMM YYYY) 16 April 2007		22. Name N/A		23. Date (DD MMM YYYY) N/A	
INSTALLER RESPONSIBILITIES							
<p>*Installer must cross-check eligibility with approved data.</p> <p>This document does not constitute authority to install the part.</p> <p>Where the installer works in accordance with the national regulations of an airworthiness authority other than the authority specified in block 1, the installer must ensure that his/her airworthiness authority accepts products or maintenance from the airworthiness authority specified in block 1.</p> <p>Statements 14 and 19 do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification, issued in accordance with the national regulations of the state of registry, before the aircraft may be flown.</p>							

1. Approving national aviation authority / country TRANSPORT CANADA		2. AUTHORIZED RELEASE CERTIFICATE TCCA 24-0078				3. Form tracking No. SO16413-2	
4. Approved organization name and address AMO 88-97		5. NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada				6. Work Order/Contract/Invoice PO 00003544	
6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work	
3	3/4 STUD	B80704-1	BELL 205A-1 205B 204B	16	BATCH # 07-1195	Manufactured ..	
4	STUD	B80705-1	UH-1H BELL 205A-1 205B 204B UH-1H	24	BATCH # 07-1196	Manufactured	
13. Remarks These Aeronautical Products conform to approved data in accordance with TCCA STC Number SH99-11 and (FAA STC Number SR00953NY and SR01395NY).							
14. Certifies that the items identified above were manufactured in conformity to:				<input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in block 13 Certifies that, except where otherwise specified in block 13, the work identified in block 12 and described in block 13 was performed in accordance with CAR 571.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 13.							
15. Authorized Signature 		16. Certificate / Approval Ref. No. AMO 88-97		20. Authorized Signature N/A		21. Certificate / Approval Ref. No. N/A	
17. Name R. D. Williamson		18. Date (DD MMM YYYY) 16 April 2007		22. Name N/A		23. Date (DD MMM YYYY)	
INSTALLER RESPONSIBILITIES *Installer must cross-check eligibility with approved data. This document does not constitute authority to install the part. Where the installer works in accordance with the national regulations of an airworthiness authority other than the authority specified in block 1, the installer must ensure that his/her airworthiness authority accepts products or maintenance from the airworthiness authority specified in block 1. Statements 14 and 19 do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification, issued in accordance with the national regulations of the state of registry, before the aircraft may be flown.							

Non-Conformance Report

NCR 198

Raised by: Dan Stew

Source: Tech Support

Sheet No. 1 of 1

Non-Conforming

Dept./Supplier: Eng.

Date:

07.08.07

Product/Service: D205-708-011

Priority: **HIGH**
LOW

Area of Standard:

QSI

QSP

QSPM

Section A

Description of Non-Conformance

Parts list incorrect. Corrections should be as follows:

MS20613-6C 18 should be qty 4 not 8
MS20613-6C 19 should be qty 12 not 8
↓ add 4

MS20613-6C 19 m19513 c2

Documents:

P/O

Invoice

W/O

Batch No.

TSR

Drawing

Forward to Director, Quality Assurance on completion of this box

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

Section B

Responsible for Investigation/CA: Jason M. To be done by:

Corrective Action

No	Initial	Action Description	Responsible	Due date	Sign/Date
1	VB	Jason M. quarantine all D205-2801 Kits in stock B31650	Jason M.	07.08.07	7.8.07
2	VB	Eng to change parts list to reflect corrections	Mark B.	07.08.10	
3	VB	Update quarantined Kits as per eng changes on parts list	c2	07/09/10	
		↳ B/W B31650 corrected and shipped 07.09.10			

Fault Category:

Preventive Action Required: NO YES #

Section C

Verification of C/A

Responsible for Verification of CA:

No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification

DQA: _____

Date: _____

QA Purposes only

N/C Closed

Date